

Date: Thursday, 9/20/2007 3:17:44 PM
 User: Eric Charbonneau

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	412 X-TUBE ,LOW NARROW AFT	
Job Number	34754		Part Number	D412664249	
Estimate Number	13020		Drawing Number	D412-664-249 U/R	
P.O. Number	:		Project Number	N/A	
This Issue	9/20/2007	S.O. No. :	Drawing Revision	U/R	
Prsht Rev.	NC		Material	:	
First Issue	/ /	Type : LANDING GEAR	Due Date	9/27/2007	Qty: 2 Um: Each
Previous Run	:				
Written By	:				
Checked & Approved By	:				
Comment	Est Rev:A New Issue 07.09.12 EC verified by: JLM				

Additional Product

PROTOTYPE**FOR ENGINEERING USE ONLY**

00206

Job Number:		
Seq. #:	Machine Or Operation:	Description:
1.0	DC	DOCUMENT CONTROL
		
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D212-664-247 CHG001		
2.0	D6008132P	Crosstube extrusion
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: ✓ Qty Part number Description Batch 1 D6008132 Crosstube 2654B U/R 25668 Check OD = 3.250", ID = 2.375" 3.500" x 2.25"		
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
		
Comment: 1-TURN AS PER FOLIO FA708 & DWG D412-664-249, FOLIO REV: / DWG REV: /		
2-DEBURR AS REQUIRED		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

800

1880 1881 1882 1883 1884

1885 1886 1887 1888 1889

1890 1891 1892 1893 1894

1895 1896 1897 1898 1899

1900 1901 1902 1903 1904

1905 1906 1907 1908 1909

1910 1911 1912 1913 1914

1915 1916 1917 1918 1919

1920 1921 1922 1923 1924

1925 1926 1927 1928 1929

1930 1931 1932 1933 1934

1935 1936 1937 1938 1939

1940 1941 1942 1943 1944

1945 1946 1947 1948 1949

1950 1951 1952 1953 1954

1955 1956 1957 1958 1959

1960 1961 1962 1963 1964

1965 1966 1967 1968 1969

1970 1971 1972 1973 1974

1975 1976 1977 1978 1979

1980 1981 1982 1983 1984

1985 1986 1987 1988 1989

1990 1991 1992 1993 1994

1995 1996 1997 1998 1999

2000 2001 2002 2003 2004

2005 2006 2007 2008 2009

2010 2011 2012 2013 2014

2015 2016 2017 2018 2019

2020 2021 2022 2023 2024

2025 2026 2027 2028 2029

2030 2031 2032 2033 2034

2035 2036 2037 2038 2039

2040 2041 2042 2043 2044

2045 2046 2047 2048 2049

2050 2051 2052 2053 2054

2055 2056 2057 2058 2059

2060 2061 2062 2063 2064

2065 2066 2067 2068 2069

2070 2071 2072 2073 2074

2075 2076 2077 2078 2079

2080 2081 2082 2083 2084

2085 2086 2087 2088 2089

2090 2091 2092 2093 2094

2095 2096 2097 2098 2099

2100 2101 2102 2103 2104

2105 2106 2107 2108 2109

2110 2111 2112 2113 2114

2115 2116 2117 2118 2119

2120 2121 2122 2123 2124

2125 2126 2127 2128 2129

2130 2131 2132 2133 2134

2135 2136 2137 2138 2139

2140 2141 2142 2143 2144

2145 2146 2147 2148 2149

2150 2151 2152 2153 2154

2155 2156 2157 2158 2159

2160 2161 2162 2163 2164

2165 2166 2167 2168 2169

2170 2171 2172 2173 2174

2175 2176 2177 2178 2179

2180 2181 2182 2183 2184

2185 2186 2187 2188 2189

2190 2191 2192 2193 2194

2195 2196 2197 2198 2199

2200 2201 2202 2203 2204

2205 2206 2207 2208 2209

2210 2211 2212 2213 2214

2215 2216 2217 2218 2219

2220 2221 2222 2223 2224

2225 2226 2227 2228 2229

2230 2231 2232 2233 2234

2235 2236 2237 2238 2239

2240 2241 2242 2243 2244

2245 2246 2247 2248 2249

2250 2251 2252 2253 2254

2255 2256 2257 2258 2259

2260 2261 2262 2263 2264

2265 2266 2267 2268 2269

2270 2271 2272 2273 2274

2275 2276 2277 2278 2279

2280 2281 2282 2283 2284

2285 2286 2287 2288 2289

2290 2291 2292 2293 2294

2295 2296 2297 2298 2299

2300 2301 2302 2303 2304

2305 2306 2307 2308 2309

2310 2311 2312 2313 2314

2315 2316 2317 2318 2319

2320 2321 2322 2323 2324

2325 2326 2327 2328 2329

2330 2331 2332 2333 2334

2335 2336 2337 2338 2339

2340 2341 2342 2343 2344

2345 2346 2347 2348 2349

2350 2351 2352 2353 2354

2355 2356 2357 2358 2359

2360 2361 2362 2363 2364

2365 2366 2367 2368 2369

2370 2371 2372 2373 2374

2375 2376 2377 2378 2379

2380 2381 2382 2383 2384

2385 2386 2387 2388 2389

2390 2391 2392 2393 2394

2395 2396 2397 2398 2399

2400 2401 2402 2403 2404

2405 2406 2407 2408 2409

2410 2411 2412 2413 2414

2415 2416 2417 2418 2419

2420 2421 2422 2423 2424

2425 2426 2427 2428 2429

2430 2431 2432 2433 2434

2435 2436 2437 2438 2439

2440 2441 2442 2443 2444

2445 2446 2447 2448 2449

2450 2451 2452 2453 2454

2455 2456 2457 2458 2459

2460 2461 2462 2463 2464

2465 2466 2467 2468 2469

2470 2471 2472 2473 2474

2475 2476 2477 2478 2479

2480 2481 2482 2483 2484

2485 2486 2487 2488 2489

2490 2491 2492 2493 2494

2495 2496 2497 2498 2499

2500 2501 2502 2503 2504

2505 2506 2507 2508 2509

2510 2511 2512 2513 2514

2515 2516 2517 2518 2519

2520 2521 2522 2523 2524

2525 2526 2527 2528 2529

2530 2531 2532 2533 2534

2535 2536 2537 2538 2539

2540 2541 2542 2543 2544

2545 2546 2547 2548 2549

2550 2551 2552 2553 2554

2555 2556 2557 2558 2559

2560 2561 2562 2563 2564

2565 2566 2567 2568 2569

2570 2571 2572 2573 2574

2575 2576 2577 2578 2579

2580 2581 2582 2583 2584

2585 2586 2587 2588 2589

2590 2591 2592 2593 2594

2595 2596 2597 2598 2599

2600 2601 2602 2603 2604

2605 2606 2607 2608 2609

2610 2611 2612 2613 2614

2615 2616 2617 2618 2619

2620 2621 2622 2623 2624

2625 2626 2627 2628 2629

2630 2631 2632 2633 2634

2635 2636 2637 2638 2639

2640 2641 2642 2643 2644

2645 2646 2647 2648 2649

2650 2651 2652 2653 2654

2655 2656 2657 2658 2659

2660 2661 2662 2663 2664

2665 2666 2667 2668 2669

2670 2671 2672 2673 2674

2675 2676 2677 2678 2679

2680 2681 2682 2683 2684

2685 2686 2687 2688 2689

2690 2691 2692 2693 2694

2695 2696 2697 2698 2699

2700 2701 2702 2703 2704

2705 2706 2707 2708 2709

2710 2711 2712 2713 2714

2715 2716 2717 2718 2719

2720 2721 2722 2723 2724

2725 2726 2727 2728 2729

2730 2731 2732 2733 2734

2735 2736 2737 2738 2739

2740 2741 2742 2743 2744

2745 2746 2747 2748 2749

2750 2751 2752 2753 2754

2755 2756 2757 2758 2759

2760 2761 2762 2763 2764

2765 2766 2767 2768 2769

2770 2771 2772 2773 2774

2775 2776 2777 2778 2779

2780 2781 2782 2783 2784

2785 2786 2787 2788 2789

2790 2791 2792 2793 2794

2795 2796 2797 2798 2799

2800 2801 2802 2803 2804

2805 2806 2807 2808 2809

2810 2811 2812 2813 2814

2815 2816 2817 2818 2819

2820 2821 2822 2823 2824

2825 2826 2827 2828 2829

2830 2831 2832 2833 2834

2835 2836 2837 2838 2839

2840 2841 2842 2843 2844

2845 2846 2847 2848 2849

2850 2851 2852 2853 2854

2855 2856 2857 2858 2859

2860 2861 2862 2863 2864

2865 2866 2867 2868 2869

Date: Thursday, 9/20/2007 3:17:44 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE ,LOW NARROW AFT

Job Number: 34754

Part Number: D412664249

Job Number:



Seq #: Machine Or Operation:

Description :

5.0 QC8



SECOND CHECK

**ENGINEERING
APPROVAL**



Comment: SECOND CHECK

07.09.05 (P) (2)

6.0 LANDING GEAR 1



LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

JB 7-9-20 (2)

1-Polish entire outside surface of crosstube

7.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(P) 07.09.20 (2)

8.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-9-21 (2)

9.0 QC3/5



INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

(2)

10.0 BENDING



BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-249 using CNC bender program and Folio FT

EL 7-9-20 (2)

11.0 QC6



DIMENSIONAL CHECK

**ENGINEERING
APPROVAL**



Comment: DIMENSIONAL CHECK

(P) 07.09.20 (2)

12.0 D36601



CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

CUFF

Batch: 34716

2-9-20

**CERTIFICATE OF CONFORMITY
REQUIRED**

(4)

Date: Thursday, 9/20/2007 3:17:44 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE ,LOW NARROW AFT

Job Number: 34754

Part Number: D412664249

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D412-664-249 .

2-Drill pilot holes in tube as per Dwg D412-664-249

3-Ream hole to finish size in tube as per Dwg D412-664-249

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-249

DP
7-9-20

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

DP/

7-9-20

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0 QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



CP 07.09.20

Comment: INSPECT WORK TO CURRENT STEP

17.0 OUTSIDE SERV.10

OUTSIDE SERVICES LG

**ENGINEERING
APPROVAL**



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: _____ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

**CERTIFICATE OF CONFORMITY
REQUIRED**

N/P CP 07.09.20

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

N/A CP 07.09.20

Date: Thursday, 9/20/2007 3:17:44 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE ,LOW NARROW AFT

Job Number: 34754

Part Number: D412664249

Job Number:



Seq. #: Machine Or Operation:

Description:

19.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING APPROVAL



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

N/A

CP
9/20/2007

20.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D412-664-249. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: H105469

DR/

7-9-20

21.0 CR3212407

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 88.0000 Each(s)

CHERRY RIVET

Batch: H104071

DR/

7-9-20

22.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

DR/ 07-09-21

2-Paint outside crosstube with White Imron as per QSI 005 4.2

N/A 07-09-21 CP

23.0 QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

N/A CP 07-09-23

24.0 D28961

Support



CERTIFICATE OF CONFORMITY
REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

Batch: 30200

27 07-09-23

Date: Thursday, 9/20/2007 3:17:44 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE ,LOW NARROW AFT

Job Number: 34754

Part Number: D412664249

Job Number:



Seq. #:	Machine Or Operation:	Description :
25.0	D31891	Chafing Shield CERTIFICATE OF CONFORMITY REQUIRED
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Chafing Shield Batch: <u>38561</u> <u>ml 07 09 21</u>
26.0	D3595 063-570	Rubber Cushion (per sq ft)
		Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.0525 sf(s) Rubber Cushion Cut to .630" X 5.70" Qty 2 Batch: <u>53835</u> <u>BT 07-09-23</u>
27.0	MS2192028	Clamp(per MIL-DTL-8783C)
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Clamp Batch: <u>07 385</u> <u>BT 07-09-23</u>
28.0	MS2192030	clamp(per MIL-DTL-8783C)
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) clamp(per MIL-DTL-8783C) <u>100154</u> <u>BT 07-09-23</u>
29.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-249 Instal support with magnobond 6398 per dwg D412-664-249, cure for 12hrs before packaging. Time & date of application: <u>10 200</u> <u>07-09-23</u> Batch: <u>(04723</u>) <u>BT 07-09-23</u>
30.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL
		Comment: INSPECT WORK TO CURRENT STEP <u>QF 07-09-23</u>

Date: Thursday, 9/20/2007 3:17:44 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 412 X-TUBE ,LOW NARROW AFT
Job Number: 34754		Part Number: D412664249
Job Number:		
Seq. #:	Machine Or Operation:	Description :
31.0	PACKAGING 1 	PACKAGING RESOURCE #1 FOR ENGINEERING USE ONLY 
Comment: HAND FINISHING RESOURCE #1 Identify and pack for shipping as per PPP D412 664-249-		N/A CP 07.09.24
32.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		07.09.25
Job Completion		 <i>U of 09.28</i>
		<i>w/o 00206</i>

PARTS LIST:

Qty	Part Number	Description
X	D412-664-249	CROSSTUBE ASSEMBLY (412 LOW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3660-1	CUFF
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6009-129.
FINISHED LENGTH = 107.82 ± 0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 10) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF
CROSSTUBE PER QSI 035.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE
D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
- 14) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A
LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 16) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

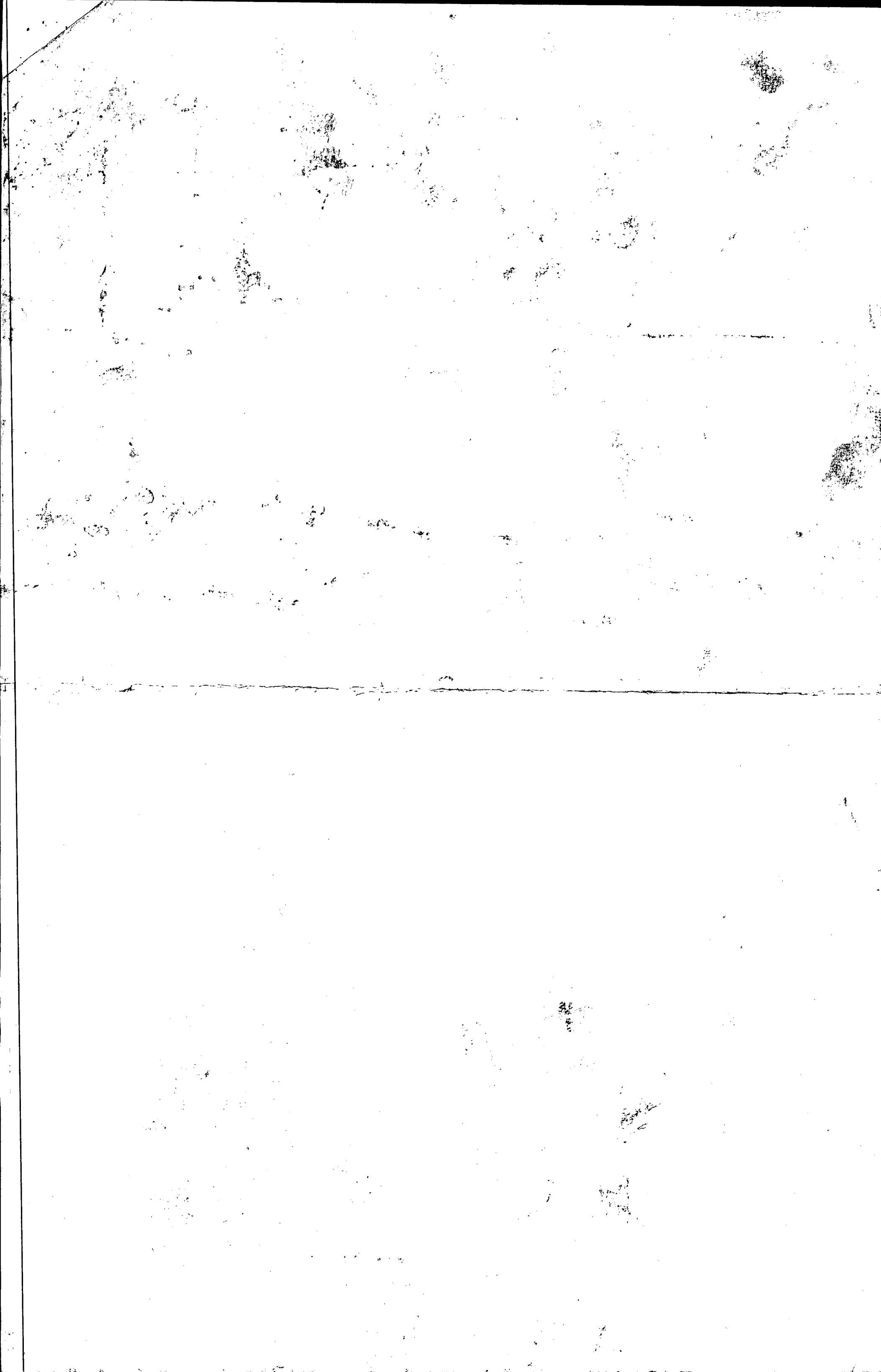
PRELIMINARY ISSUE

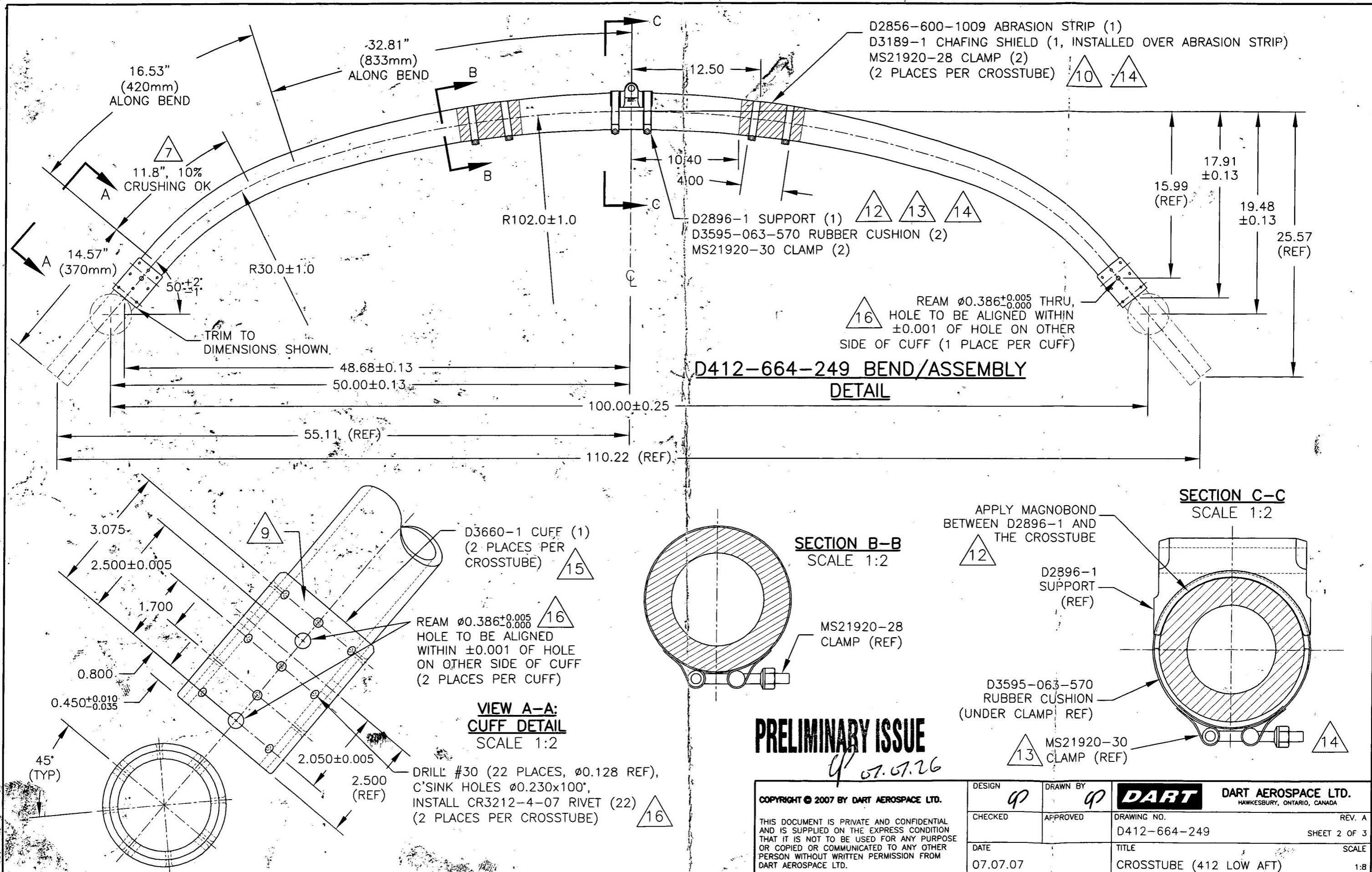
IP 07.07.07

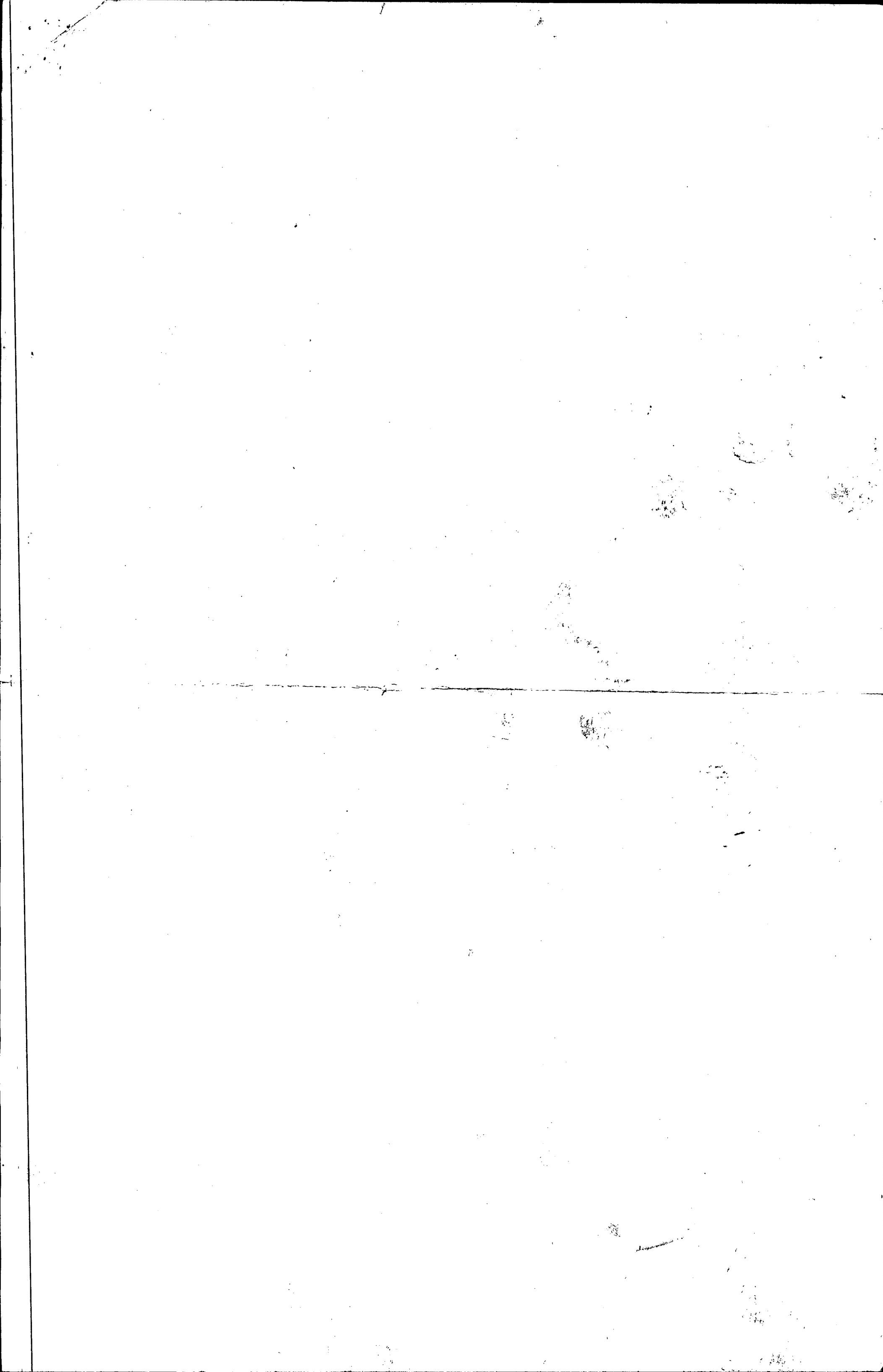
A	07.07.07	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DRAWING NO.
DATE	TITLE	SCALE
07.07.07	CROSSTUBE (412 LOW AFT)..	1:8

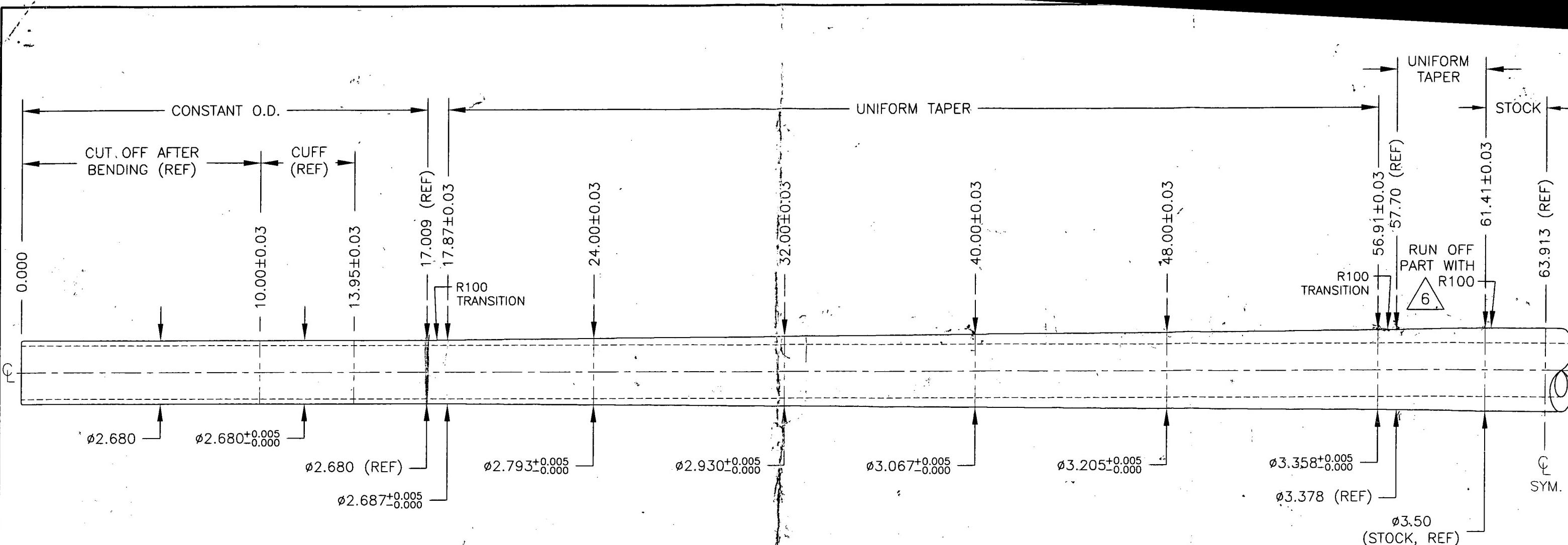
COPYRIGHT © 2007 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.









D412-664-249 MACHINING DETAIL

PRELIMINARY ISSUE
GP 07.07.26

COPYRIGHT © 2007 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D412-664-249 REV. A
DATE		TITLE	SCALE 1:4

07.07.07

CROSSTUBE (412 LOW AFT)

SHEET 3 OF 3

2

DART AEROSPACE LTD	Work Order:	COZ06 34754 A
Description: Crosstube Assembly	Part Number:	0412-664-249-1
Inspection Dwg: D412-664-249 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	Ø 3.500"	± .030" 3.500	/			
	Ø 3.378"	± .010" 3.378	/			
	Ø 3.358"	± .005" 3.362	/			
	Ø 3.205"	± .005" 3.209	✓			
	Ø 3.067"	± .005" 3.071	✓			
	Ø 2.930"	± .005" 2.934	✓			
	Ø 2.793"	± .005" 2.797	✓			
	Ø 2.687"	± .005" 2.681	/			
	Ø 2.680"	± .010" 2.684	✓			
	Ø 2.680	± .005" 2.684	✓			
SIDE B	127.826	± .020" 127.750	/ *			
	Ø 3.500	± .030" 3.500				
	Ø 3.378	± .010" 3.378				
	Ø 2.680"	± .010" 2.684				
	Ø 3.358	± .005" 3.362				
	Ø 3.205"	" 3.209				
	Ø 3.067"	" 3.071				
	Ø 2.930"	" 2.934				
	Ø 2.793"	" 2.797				
	Ø 2.687"	" 2.671				
	Ø 2.680"	" 2.684				
127.826" ± .020"						

Measured by:	J.F.	Audited by:	S.F.	Prototype Approval:	P N/A
Date:	07/09/05	Date:	07/09/05	Date:	07/09/05
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

* COMPENSATE BY cutting off 9.96 ± 0.03 " AT either end of the
TUBE. INSTEAD OF 10.00" AS per drawing.

107.02.06

DART AEROSPACE LTD	Work Order:	COZ06 34754 B
Description: Crosstube Assembly	Part Number:	0412664249-2
Inspection Dwg: 0412664249 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	3.500	+-.030	3.500	✓		
	3.378	+-.010	3.382	✓		
	3.358	+-.005	3.362	✓		
	3.205	"	3.209	✓		
	3.067	"	3.071	✓		
	2.930	"	2.934	✓		
	2.793	"	2.797	✓		
	2.687	"	2.691	✓		
	2.680	+-.010	2.685	✓		
	2.680	+-.005	2.685	✓		
SIDE B	2.680	+-.000	2.685	✓		
	127.826	+-.020	127.826	✓		
	3.500	+-.030	3.500			
	3.378	+-.010	3.382			
	3.358	+-.005	3.362			
	3.205	"	3.209			
	3.067	"	3.071			
	2.930	"	2.934			
	2.793	"	2.797			
	2.687	"	2.681			

Measured by:	<i>JL</i>
Date:	07/09/06

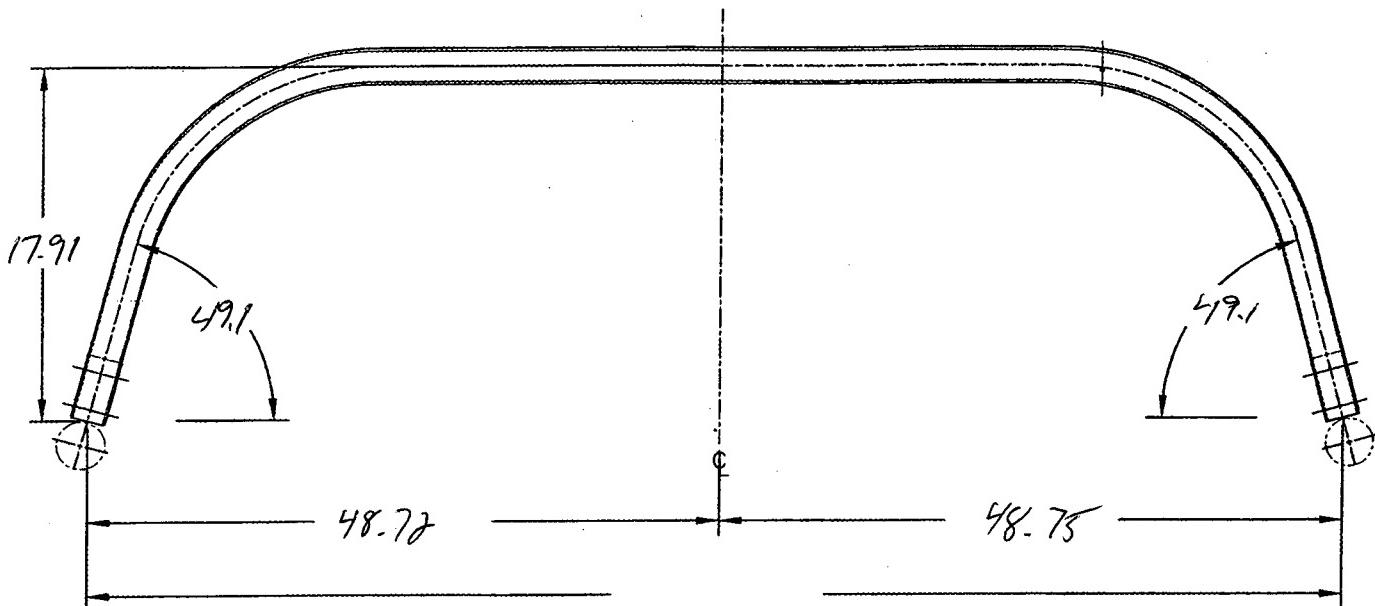
Audited by:	<i>PB</i>
Date:	07/09/06

Prototype Approval:	<i>JP</i>	N/A
Date:	07/09/06	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	B 00206-1 34754 A
Description:	Part Number:	412-664-249
Inspection Dwg: D412-664-249 Rev: A Prelm. Issue		Page 1 of 1

Required Dimension	Min	Max
Height		
1/2 Span		
Angle		
Total Span		



Comments

QC15 Inspection	<i>CP</i>
Date	07.09.20

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	06.09.19	Reformat; QC level revised	KJ/JM	
C	07.02.06	Reformat	KJ/JM	



DART AEROSPACE LTD

Work Order:

B00206-2

Description:

Part Number:

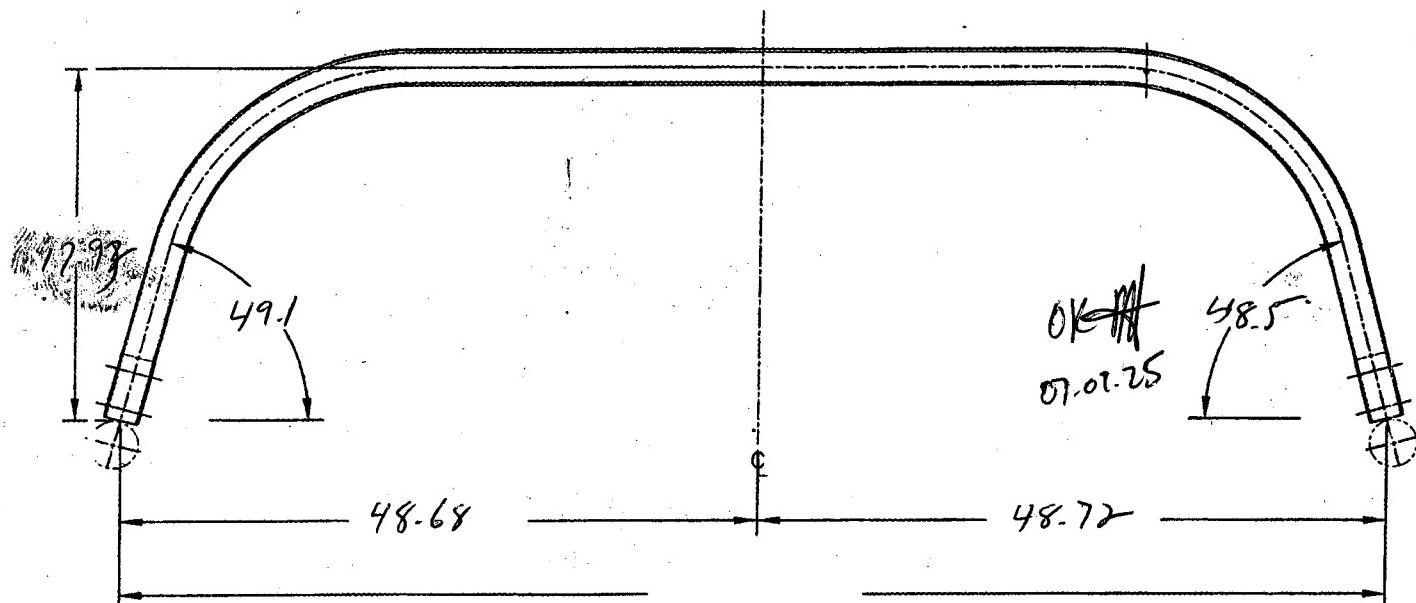
34754B

410-664-249

Inspection Dwg: D212-664-249 Rev: A Prelim Issue

Page 1 of 1

Required Dimension	Min	Max
Height		
1/2 Span		
Angle		
Total Span		



Comments

QC15 Inspection	CP
Date	07.09.20

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	06.09.19	Reformat; QC level revised	KJ/JM	
C	07.02.06	Reformat	KJ/JM	

